

Work Order ID 85117

85117

AGAP

Page 1

Friday, June 01, 2012 4:05:25 PM

Item ID: PB67-43001-79

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Blade Support Assembly

Start Date: 6/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *12-06-04* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

C

100 Weld per dwg A/R Aluminum rod Batch: *120854* 0.00

100

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg PB67-43001

2 0

12.06.13

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

2

✓

12.06.15

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

5/12/06/14

(A)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85117***85117***

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N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Blade Support Assembly

Start Date: 6/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

*** put screws in nut plates before to keep thread clean***

START TIME: 2:30OVEN TEMPERATURE: 320°FFINISH TIME: 3:00

2X

✓

M/L
12/06/18

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

2 ✓

BL 12-6-18

150

Identify as per dwg & Stock Location: UMA

0.00

150

Packaging

Memo

0.00

Packaging

2 ✓

M/L
12.06.20

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Start Date: 6/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/2012
M25 12/06/20

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Picklist Print

Friday, June 01, 2012 4:05:25 PM

Page 1

Work Order ID: 85117

Parent Item: PB67-43001-79

Parent Item Name: Lower Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-171 Mounting Plate		Manufactured	No		341563 = 4 385118 = 8	100	Each	16.0000	6	12		6/12.06.13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST446A		16				12			
				41563		16							
PB67-43001-177 Short Support Plate		Manufactured	No		385121 = 2	100	Each	0.0000	1	2		6/12.06.13	
PB67-43001-179 Short Side Plate		Manufactured	No			100	Each	1.0000	2	4		6/12.06.13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz	385122 = 4	1				4			
				52431		1							

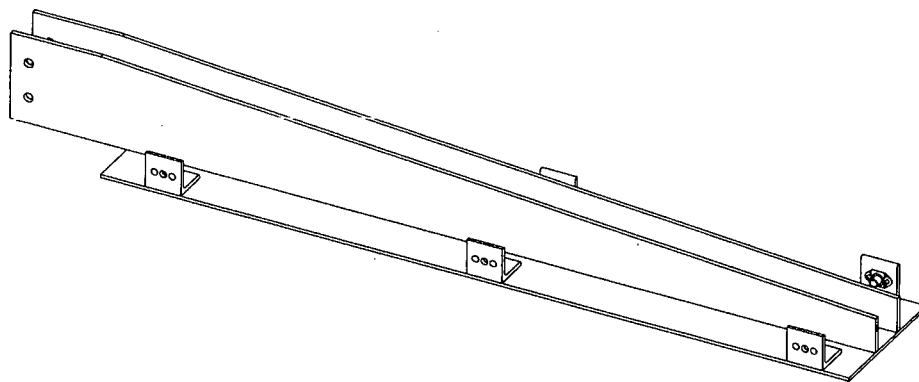
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B67-43001-79 LOWER BLADE SUPPORT ASSY

ITEM	QTY -79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.96 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JS			
CHECKED	JS	DRAWING NO.	REV. C	
MFG. APPR.	JS	B67-43001-79	SHEET 1 OF 2	
APPROVED	JS	TITLE	SCALE	
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS	
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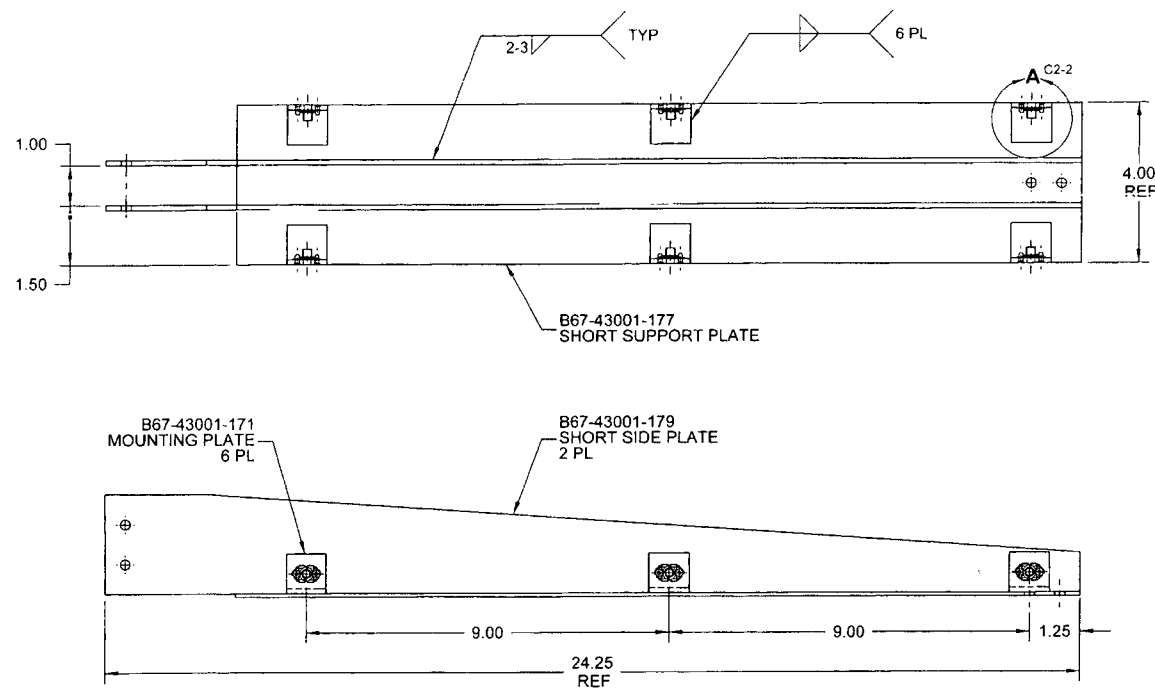
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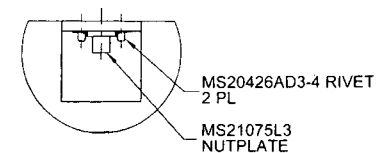
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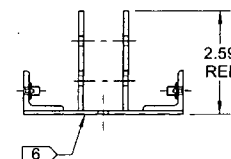


B67-43001-79 LOWER BLADE SUPPORT ASSY



DETAIL A
SCALE 2X, 6 PL

85117



RELEASED
2009-09-24
MP

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	B67-43001-79	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
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8 7 6 5 4 3 2 1

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